

SHIP TODAY

Work Order ID 56209

February 16, 2010 10:59:36 AM



Page 1

Item ID: D4070-041

Accept



Setup

Start



Revision ID:

Stop



Item Name: Clamp

Start Date: 2/16/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr Revision Nbr

D4070

A

100



Waterjet

Memo

0.00

10-2-16

FLOW CNC Waterjet

Cut as per dwg

Prog rev: *A*

dwg rev: *A*

110



QC2- Inspect parts off machine FAI/FAIB

0.00

10-2-16

QC

Memo

0.00

Quality Control

120



QC8- Inspect parts - second check

0.00

Subtotal

QC

Memo

0.00

Quality Control

88

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Page 2

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Cust Item ID:

Required Date: 2/16/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Form as per dwg

0.00

100216⑨

PTO
last page

Brake NC

Memo

0.00

Brake NC

140



QC5- Inspect part completeness to step on W/O

0.00

10.02.17 ⑤

QC

Memo

0.00

Quality Control

150



Small Fab

Memo

0.00

Small Fab

Assemble rubber cushion as per dwg

100217

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10.02.17	130	<ul style="list-style-type: none"> - Width of opening is 0.250" instead of 0.100 - Acceptable based on test 100% part install - No powder coat 				GP 10.02.17 PC 451442	/ 1002.17

Part No: D4070-1 PAR #: Fault Category: Small Lub NCR: Yes No DQA: Date: 10.02.17
 Resolution: Scraps Disposition: Scrap QA: N/C Closed: Date:

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10.02.17	130	4 parts scrap. did not form correctly, due to being a new part & no tooling is off yet. Parts are rush. QC process.	/ VSL442	<ul style="list-style-type: none"> - Scrap & destroy - New parts: Tooling is going to be made or parts will be subcontracted 	10.02.17	/ 10.02.17	/ 10.02.17	/ 10.02.17

NOTE: Date & initial all entries

Work Order ID 56209

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Setup Start



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Start Date: 2/16/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/16/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

P 16.02.17 (S)

170



Packaging

Packaging

Memo

0.00

P 16/2/17 (S)

180



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/17 AJ

BY 10-2-17
(5)

Picklist Print

February 16, 2010 10:59:35 AM

Page 1

Work Order ID: 56209



Parent Item: D4070-041



Parent Item Name: Clamp

Start Date: 2/16/10

Required Date: 2/16/10

Comments: IPP rev A 10.02.16 new issue EC verified by: DD

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D2182B



Manufactured

No

f 176.2040 0.3158



Rubber Cushion

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

ST	29.886	
28042	7.33	
30872	0.33	
45405	22.226	

Main Warehouse

ST410	146.318	
52649	146.318	

ST 100207

Cut qty 1 at 1.80" long

M304S16GA



Purchased

No

100 sf 192.0899 0.0400

2

R310-2-16

304/316 Sheet .063

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
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Location

Main Warehouse

MAT	192.0898737	
106860	8.0295	
111924	25.1689737	
112442	29.8865	
113295	129.0049	

9

113295

DART AEROSPACE LTD	Work Order:	56209
Description: Clamp	Part Number:	D4070-1
Inspection Dwg: D4070-1 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

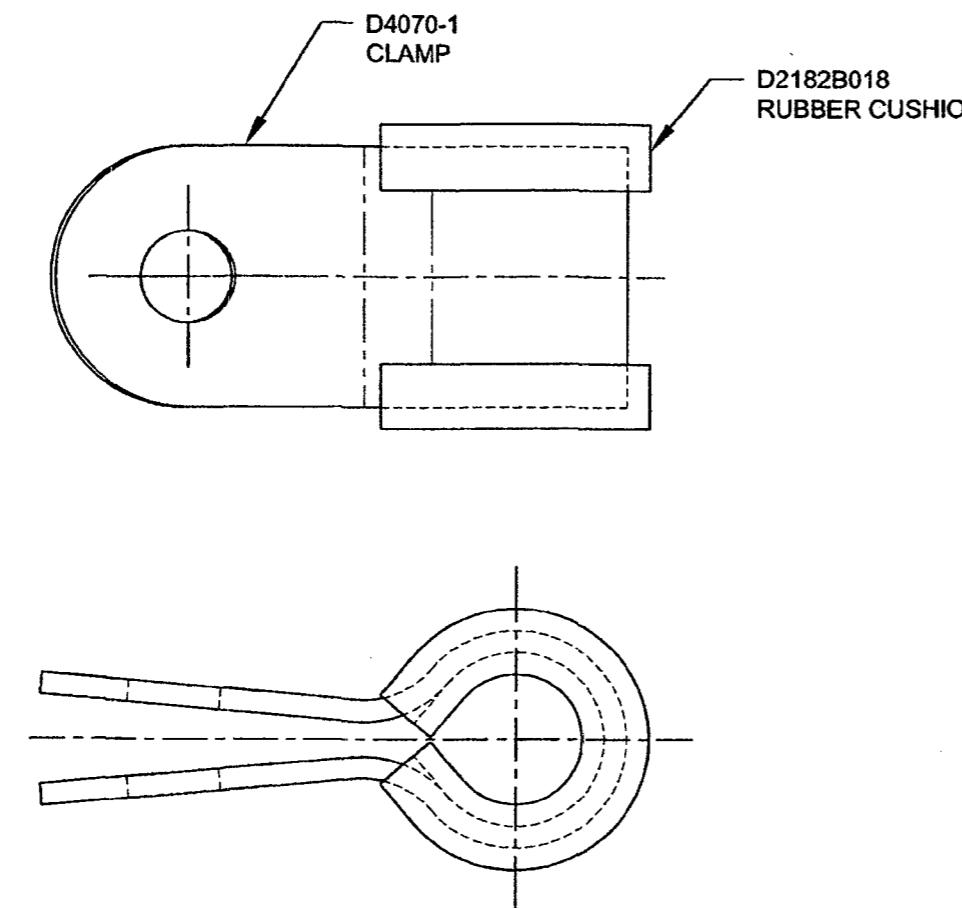
Measured by:	VR	Audited by:	S	Prototype Approval:	N/A
Date:	10-2-16	Date:	10/02/16	Date:	N/A

Rev	Date	Change	Revised by	Approved
A		New Issue	P/O D4070-041	KJ/JLM

8 7 6 5 4 3 2 1

QTY	PART NUMBER	DESCRIPTION
X	D4070-041	CLAMP
1	D4070-1	CLAMP
1	D2182B018	RUBBER CUSHION

D
c6 52009



D4070-041 CLAMP

RELEASED
2010-02-16
MP

A

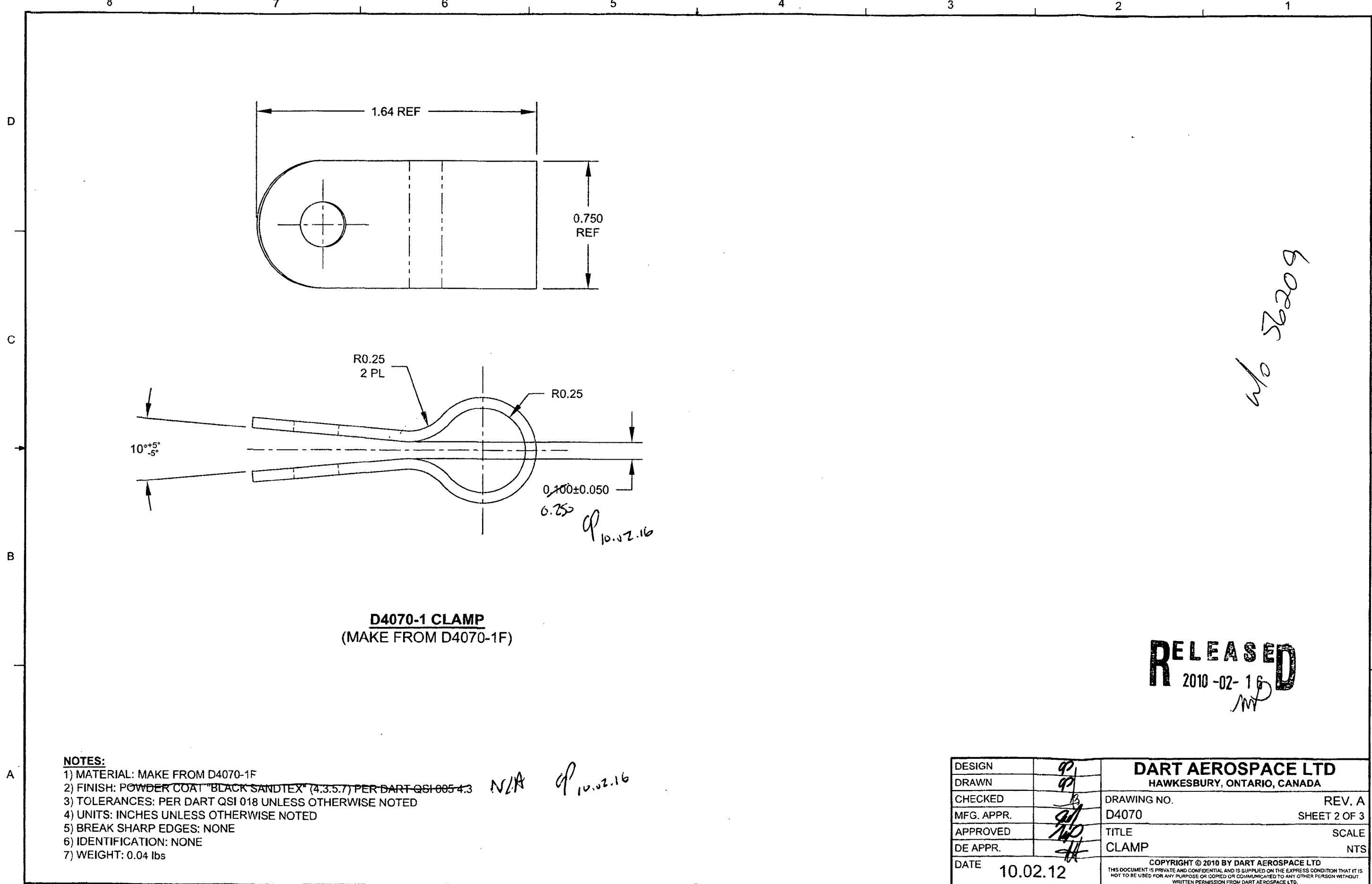
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4070-041" USING REMOVABLE TAG
- 7) WEIGHT: 0.05 lbs

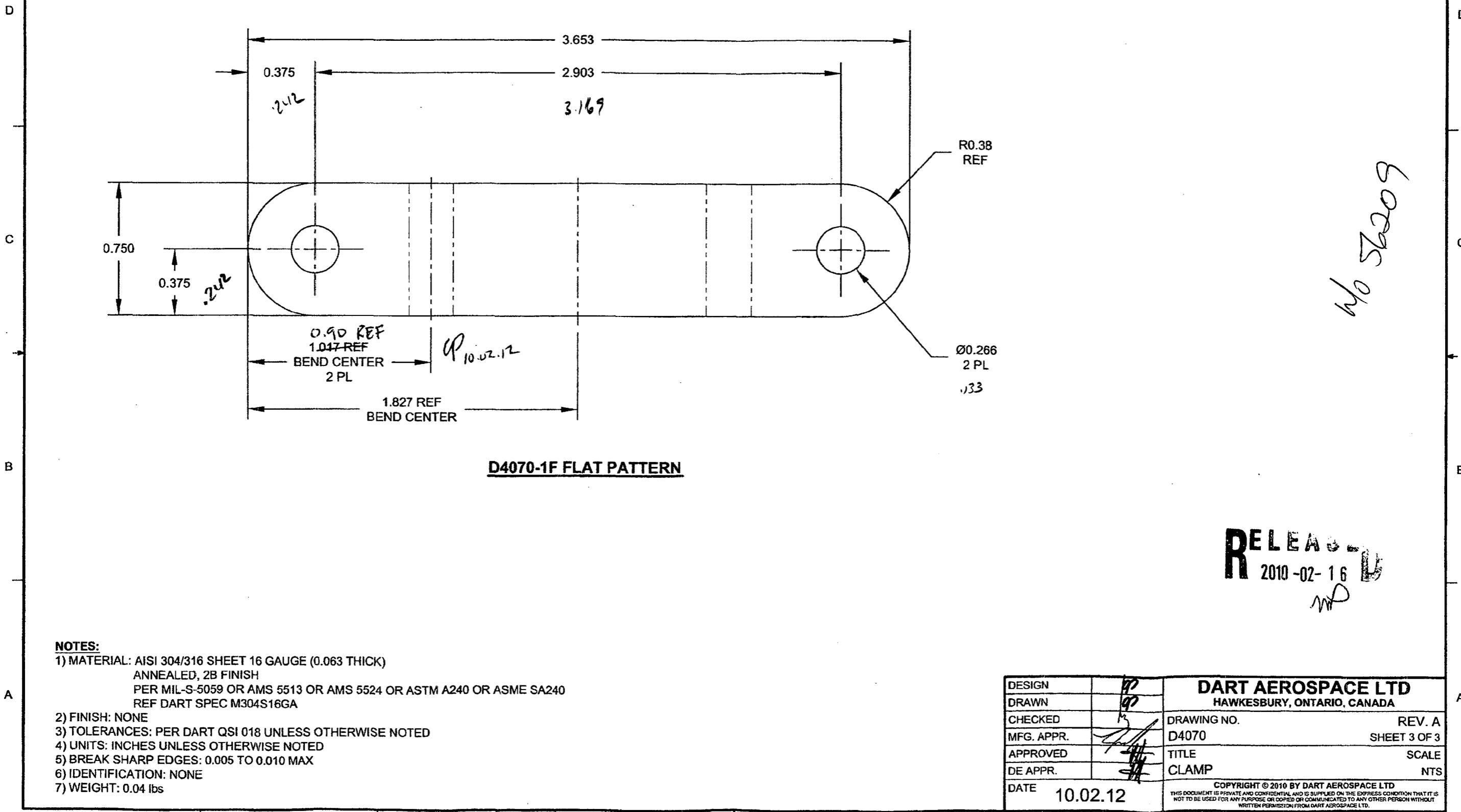
8 7 6 5 4 3 2 1

A	NEW ISSUE	CP	10.02.12
REV.	DESCRIPTION	BY	DATE
DESIGN	99	DART AEROSPACE LTD	
DRAWN	99	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4070	SHEET 1 OF 3
APPROVED		TITLE	SCALE
DE APPR.		CLAMP	NTS
DATE	10.02.12	COPYRIGHT © 2010 BY DART AEROSPACE LTD	

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8 7 6 5 4 3 2 1



8 7 6 5 4 3 2 1